



Work Order ID 102051

\*102051\*

May-23-13 7:44:21 AM

Page 2

Item ID:	D3183-041	Accept	*N900040100*	Setup	Start	*NS1*	
Revision ID:							
Item Name:	Bracket Assembly					Stop *NS2*	
Start Date:	5/23/13	Start Qty:	2.00	*2*	Cust Item ID:		
Required Date:	5/31/13	Req'd Qty:	2.00	*2*	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00	TK	13/05/27		4	6		
140 <b>*140*</b> Small Fab Small Fab	Small Fab  Memo	0.00				4x			
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00	DAS 21 9-6	BS27		4			

# Picklist Print

May-23-13 7:44:21 AM

Page 1

Work Order ID: 102051

Parent Item: D3183-041

Parent Item Name: Bracket Assembly

Start Date: 5/23/13

Required Date: 5/31/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:Pick:A04.02.18New issueKJ/DS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3121-21 Bolt		Manufactured	No			140	Each	71.0000	2	4		23/05/27	
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Location	Loc Qty	Loc Code
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ST235	71	
99292	41	
99601	30	

D3183-045 Bearing Assembly		Manufactured	No			100	Each	33.0000	2	4		23/05/27	
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Location	Loc Qty	Loc Code
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FG	5	
88587	5	
ST235B	28	
96471	27	
97336	1	

M174B2.000X01.500 17-4 SS Bar 2.00 x 1.500		Purchased	No			140	f	7.5760	0.4583	0.9648421		23/05/27	
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Location	Loc Qty	Loc Code
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MAT049	7.576	
113189	7.576	

1.5

1124081

DART AEROSPACE LTD		Work Order:	102051
Description: Bracket		Part Number:	D3183-1
Inspection Dwg: D3183	Rev: C1		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.400	+/-0.010					
0.182	+/-0.010	184	—		Vern	ML-06
0.070	+/-0.010	072	—		"	
0.100	+/-0.010	097	—		"	
R0.063	+/-0.010	R.063	—		R-6	
R0.189	+/-0.010	R.187	—		"	
3.881	+/-0.010	3.882	—		Vern	ML-06
4.17	+/-0.030	4.170	—		"	
0.830	+/-0.010	830	—		"	
0.500	+/-0.010	500	—		"	
0.218	+/-0.010	216	—		"	
1.030	+/-0.010	1.030	—		"	
1.90	+/-0.030	1.891	—		"	
1.012	+/-0.010	1.014	—		"	
0.786	+/-0.010	786	—		"	
R0.19	+/-0.010	R.190	—		R-6	
Ø0.392	+0.002/-0.000	Ø.3933	—		Vern	ML-02
0.162	+/-0.010	163	—		Vern	ML-02
2.799	+/-0.010	2.799	—		"	
2.075	+/-0.010	2.075	—		"	
0.162	+/-0.010	161	—		"	
0.032	+/-0.010	030	—		"	
0.381	+/-0.010	375	—		"	
0.200	+/-0.010	197	—		"	

Measured by:	<i>CK</i>	Audited by:	<i>PK</i>	Prototype Approval:	N/A
Date:	13/05/27	Date:	13/05/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3183-041/-042)	KJ/JLM <i>JK</i>	<i>JK</i>



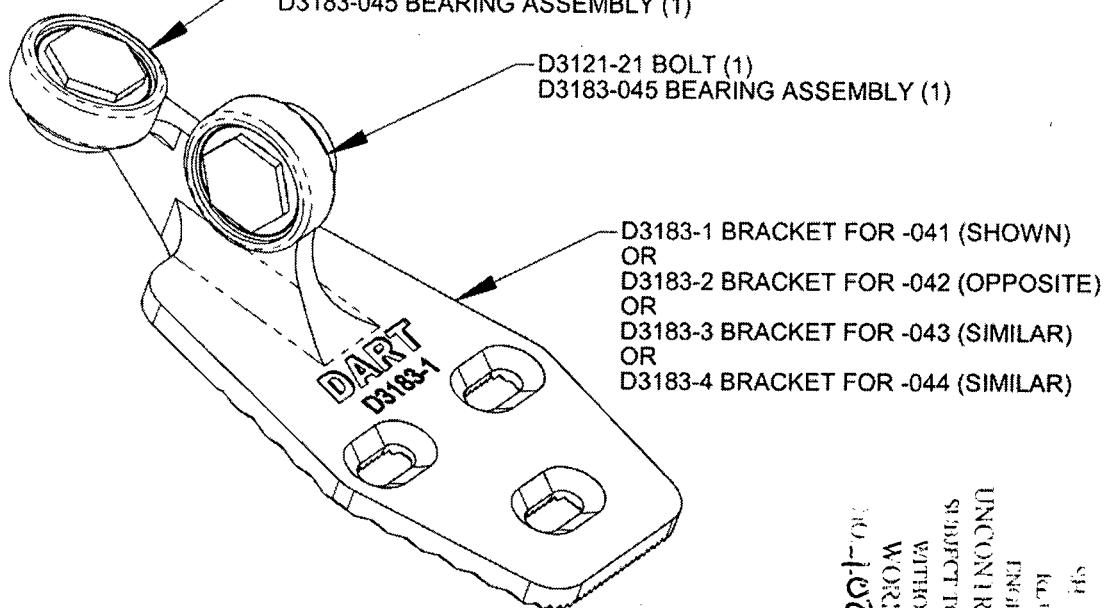
CCG  
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 1 OF 4

DATE 04.02.17 TITLE SCALE 1:1  
BRACKET ASSEMBLY

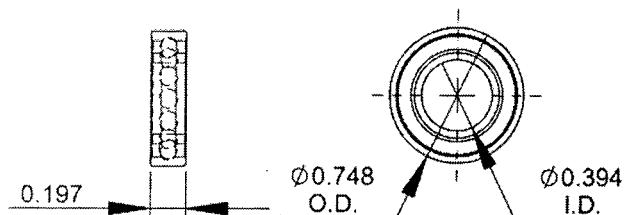
A	03.01.24	NEW ISSUE
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882
C	04.02.17	ADD -045-9; 0.182 WAS 0.431
C1	04.11.09	0.830 WAS 0.850

RELEASED  
04.03.01 C1  
DEO ATTACHED



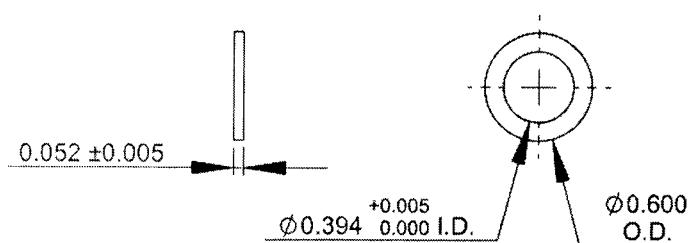
**D3183-041 BRACKET ASSEMBLY (SHOWN)**  
**D3183-042 BRACKET ASSEMBLY (OPPOSITE)**  
**D3183-043 BRACKET ASSEMBLY (SIMILAR)**  
**D3183-044 BRACKET ASSEMBLY (SIMILAR)**

SHIPPING COPY  
TORONTO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
10-10205-13-05-23  
10-10205-13-05-23



#### **D3183-5 BEARING: SPECIFICATION CONTROL DRAWING**

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



#### **D3183-7 WASHER**

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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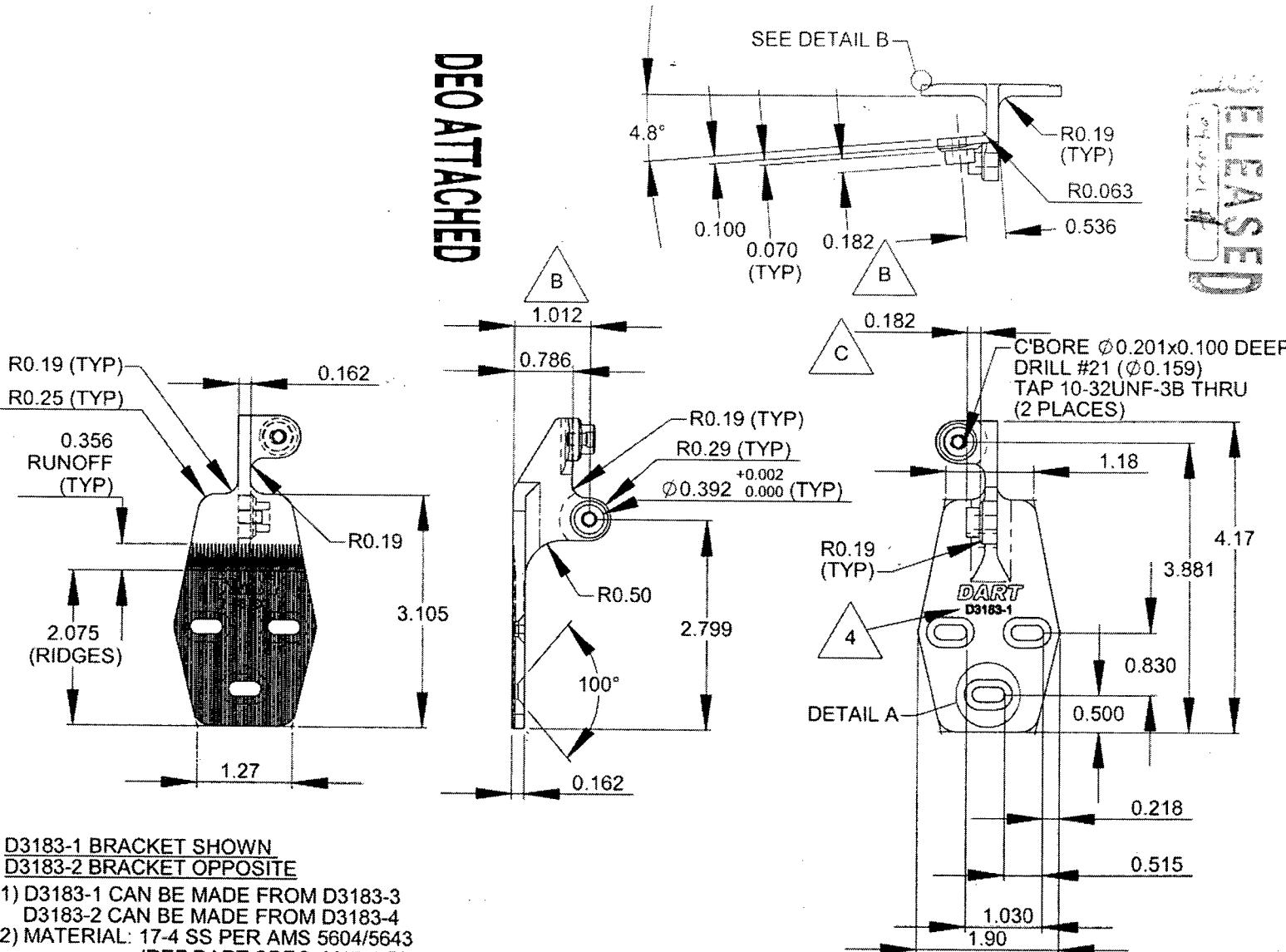
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OF  
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CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 2 OF 4
	TITLE	SCALE
	BRACKET ASSEMBLY	1:2

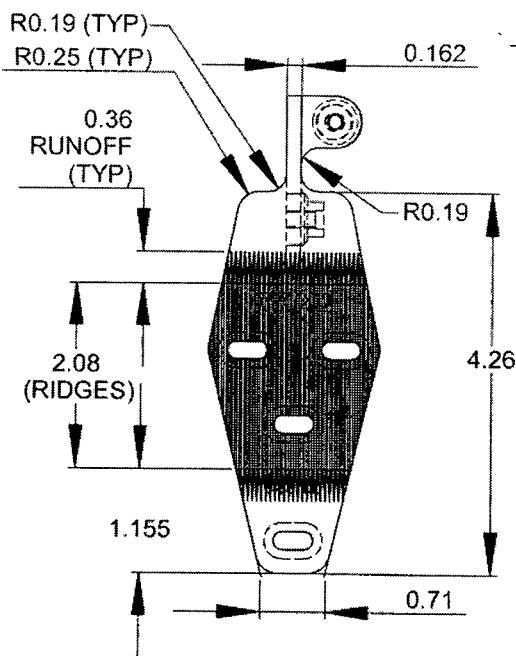


D3183-1 BRACKET SHOWN  
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3  
 D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
 (REF DART SPEC. M17-4-B)  
 MIN ULTIMATE STRENGTH = 150 ksi  
 MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS  
 OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

102057

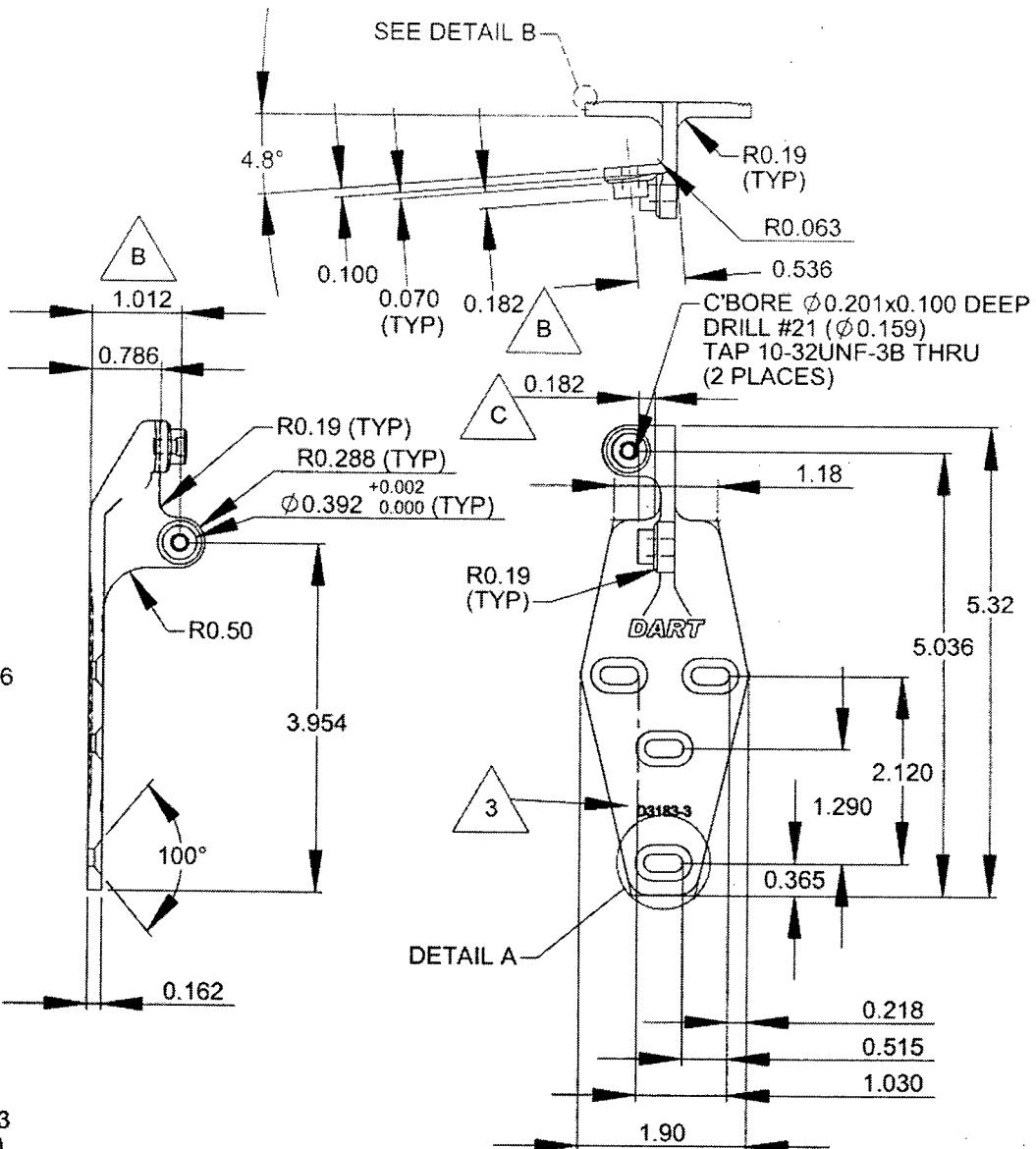
DETACHED



D3183-3 BRACKET SHOWN  
(REPLACES BELL P/N 412-030-304-105)

D3183-4 BRACKET OPPOSITE  
(REPLACES BELL P/N 412-030-304-106)

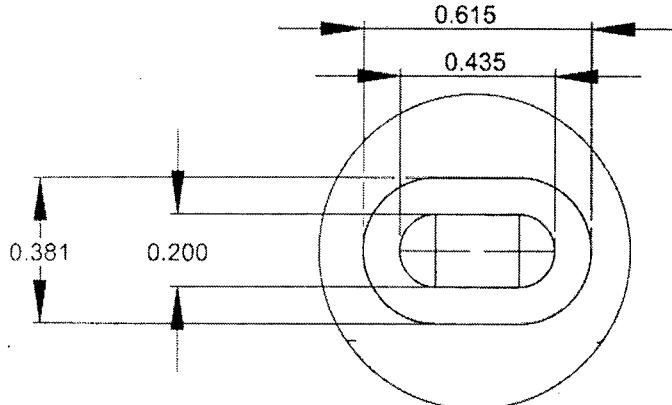
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE STRENGTH = 150 ksi  
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES



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		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D3183	SHEET 3 OF 4
DATE	TITLE	SCALE	
04.02.17	BRACKET ASSEMBLY	1:2	



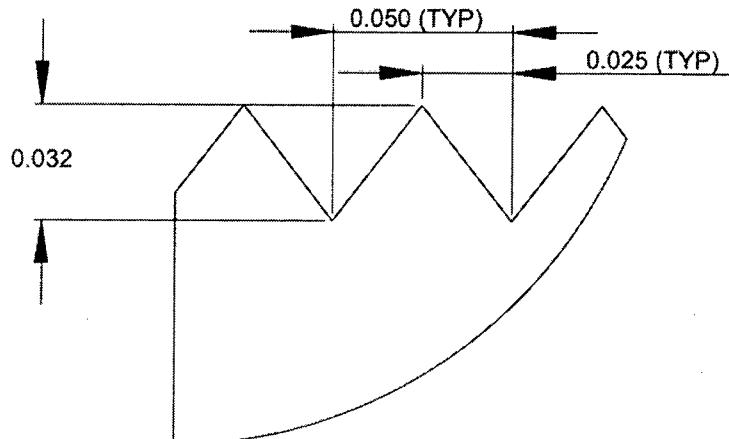
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C SHEET 4 OF 4
DATE	04.02.17	TITLE	SCALE 1:1



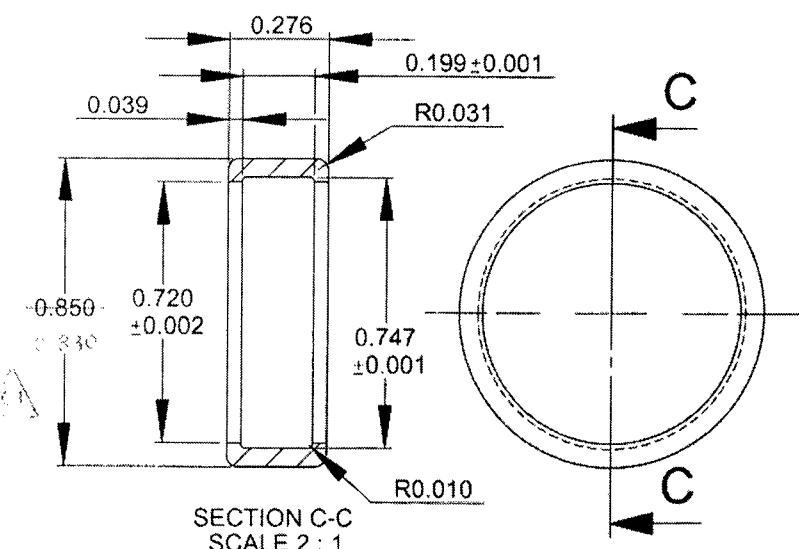
DETAIL A (2 : 1)

RELEASED  
04-03-01

DEO ATTACHED



DETAIL B (20 : 1)



#### D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

#### D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

102051

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102051

DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>ls</i>	MFG. APPR. <i>AA</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30	DATE 10/06/30	DATE 10/06/30	

D3183-5 BEARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]  
 Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

RELEASED  
 2010-07-22  
*MP*

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